

mm
07/07/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 163274

Tuesday, June 27, 2017 12:00:44 PM

163274

Page 2

Item ID: D3197-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.67				4	0		DAS 45 9-89 2017-07-14
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4	0		DAS 49 9-89 17/07/15
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.46				(X4)	0		20170725 BEB.

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
24 CA								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 163274

Tuesday, June 27, 2017 12:00:44 PM

163274

Page 3

Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 136370</i> Memo START TIME: <i>1:40</i> <i>8:00</i> FINISH TIME: <i>2:10</i>	0.00 0.42				<i>4</i>	<i>Ø</i>	<i>17-07-25</i>	<i>34 0.00</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>4</i>			<i>DAG 38 9-89</i> <i>JUL 25 2017</i>
180 *180* Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.67				<i>3</i>	<i>Ø</i>	<i>JUL 26 2017</i>	<i>DAG 19 9-89</i>

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Tuesday, June 27, 2017 12:00:44 PM

163274

Page 4

Item ID: D3197-041 Accept ***N9000040100*** Setup Start ***NS1***
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 Item Name: Bar
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 Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190						3			DAS 38 9-89
QC	Memo	0.08							JUL 26 2017
Quality Control									
200	Identify as per dwg & Stock Location: <u>56256</u>	0.00							
200						3			JUL 16 2017
Packaging	Memo	0.04							DAS 6 9-89
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									JUL 26 2017
QC	Memo	0.40							DAS 21 9-89
Quality Control									

DAS
21
9-89
JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, June 27, 2017 12:00:41 PM

Page 1

Work Order ID: 163274

163274

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 7/6/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 - *MS27039-1-24* Screw		Purchased	No			100	Each	56.0000	2	8		JUL 26 2017	DAS 19 9-09
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST279	56				(8)			
					m134537	56							
D2690-5 - *D2690-5* Lanyard Assembly		Manufactured	No			180	Each	6.0000	2	8		JUL 26 2017	DAS 19 9-09
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST009	6				(2)			
					160323	6							
D3242-1 - *D3242-1* Tag		Manufactured	No			180	Each	11.0000	2	8		JUL 26 2017	DAS 19 9-09
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					GA	11				(5)			
					137274	1							
					158463	10							
D3489-3-200 - *D3489-3-200* Pip Pin		Manufactured	No			180	Each	7.0000	2	8		JUL 26 2017	DAS 19 9-09
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					GA	7							
					161623	7							

B 163854
not pulled



DART
AEROSPACE

Work Order update only

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

Picklist Print

Tuesday, June 27, 2017 12:00:42 PM

Page 2

Work Order ID: 163274

163274

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 7/6/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000

Purchased

No

180

f

28.2460

2.42

12.1

M7075T73R1 000

7075-T73 Rd Bar 1.00

**

DAS
49
9-89

17/07/12

Location

Loc Qty

Loc Code

MAT

2.036

m137041

2.036

MAT012

26.21

m137217

26.21

MS21042L3

Purchased

No

180

Each

1,475.000

2

8

MS21042L3

Nut

**

JUL 26 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

OVER007

500

m134360

0

m137886

500

ST303

502

m137680

502

NAS1149D0363J

Purchased

No

180

Each

690.0000

6

24

NAS1149D0363J

Washer

**

JUL 26 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

43

m134055

13

m137164

30

ST263

647

m137587

647

137963

Tuesday, June 27, 2017 12:00:42 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

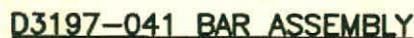
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		OTHER : _____																							

06.03.21 4
2021.03.21

ART



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
JECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN		CP	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D3197	REV. B
DATE	06.01.10			TITLE	BAR	SHEET 1 OF 1
				SCALE	1:1	
A	03.07.01			NEW ISSUE		
B	06.01.10			CHG PIP PIN; ADD D3242-1 TAG		

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